

Work Order ID 50762

July 21, 2009 2:40:09 PM



Page 1

Item ID: D2596

Accept



Setup

Start



Revision ID: D

Stop



Item Name: Web, 205 Skidtube

Start Date: 07/22/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 07/31/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *MK*

Date: *09-07-21*

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2596	Rev D

100 0.00

Skidtubes

Skidtubes 0.00

Skidtubes Memo 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr

10 Ø - AWM 8-8-20

110 0.00

HandFinish

Hand Finishing 0.00

10 Ø - AWM 7-8-20

120 0.00

QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

⇒ Ø 0.630 ± 0.010

(ND)

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept



Setup Start



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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

130



Packaging

Packaging

**Operation
Description**Identify as per dwg & Stock Location: L-GSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

10

0

4W17-8-20

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/08/2010

MF 09-08-21

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 50762



Parent Item: D2596RevD



Parent Item Name: Web, 205 Skidtube

Start Date: 07/22/2009

Required Date: 07/31/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-3-100RevU/R		Manufactured	No			100	Each	0.0000	10.0000			10

Ext'n - I Beam Web 4"

Barcode for Ext'n - I Beam Web 4"



B-40196 4WM 9-8-20

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

DART

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>JH</i>	APPROVED <i>JH</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1	
DATE 07.04.17		TITLE 205 WEB	SCALE 1:20	
A	96.09.16	NEW ISSUE		
B	97.07.23	Ø0.63 HOLE WAS Ø0.56		
C	98.09.14	INCORPORATED DEO 9097		
D	07.04.17	INCORPORATED DEO 9183		

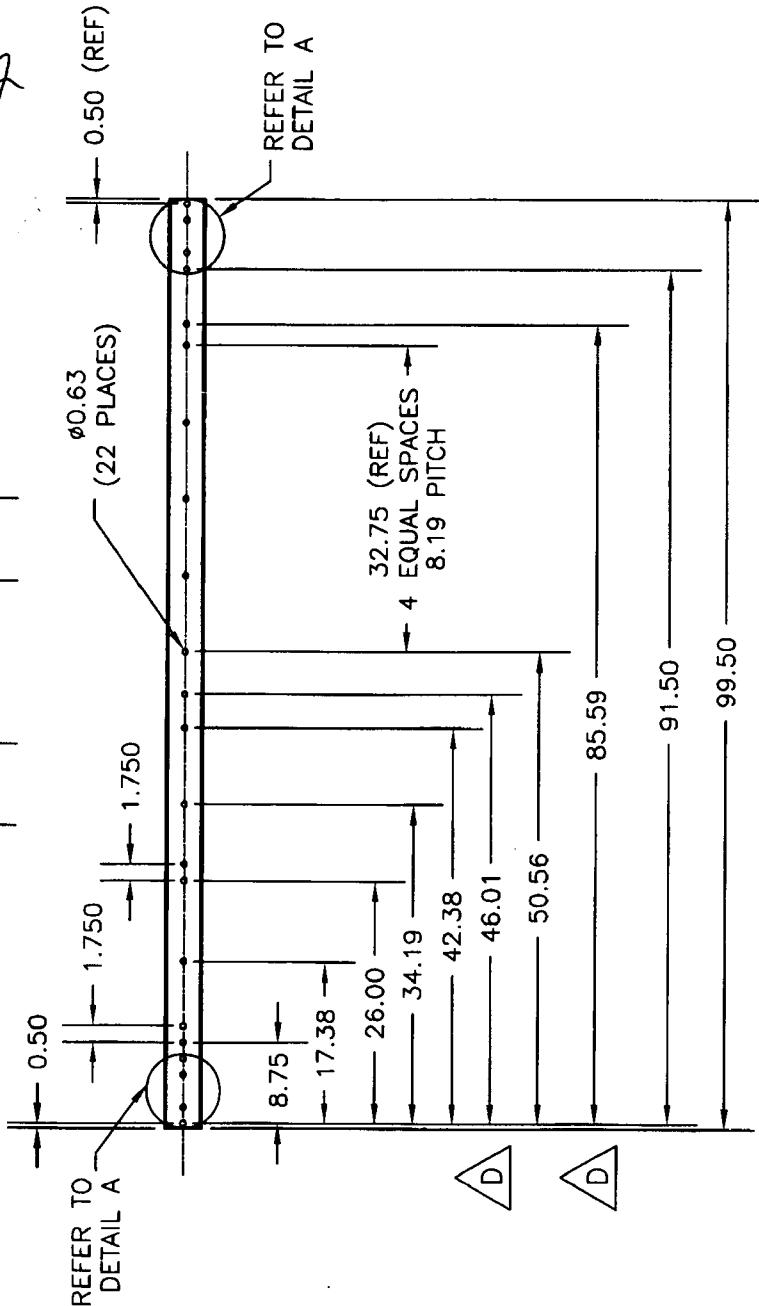
RELEASED
07-06-08 #

07.06.08

#50762

A technical diagram showing a large circle representing a cylinder. Inside the cylinder, there are four small circles arranged in a vertical column. A vertical line passes through these four circles. To the right of the cylinder, a horizontal dimension line indicates a total width of 3.500 units, spanning from the left edge of the cylinder to the right edge of the cylinder.

DETAIL A
SCALE 1:4



D2596 WEB

1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) DEBURR SHARP EDGES 0.010 TO 0.020

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